

(3)



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-312
Job Sheet 174894



Part No: D350-591-312

Job Qty: 10 ea

Part Name: *Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/22/18

Job Tracking No:

Due Date: 7/20/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Large Fab-4		RM 18-7-10
110	Large Fab	10 pcs	7/19/18	7/19/18	0.00	10.00	Large Fab 2	CPC	18-7-10
120	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC9		18-07-11
130	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC5		18-07-11
140	HandFinish	10 pcs	7/19/18	7/19/18	0.00	1.87	HandFinish1		SA 18-07-12
150	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC7-2		CPC
180	Large Fab	10 pcs	7/19/18	7/19/18	0.00	10.00	Large Fab 2		CPC
190	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC10		SA
200	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC5		SA
210	HandFinish	10 pcs	7/19/18	7/19/18	0.00	1.87	HandFinish1		SA 18-07-19
220	Powdercoat	10 pcs	7/19/18	7/19/18	0.00	2.98	Powdercoat1		SA 18-7-20
230	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.87	HandFinish3		SA 18-07-22
240	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC3		SA 18-07-24
250	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging1-3		JUL 24 2018
260	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC4		SA 18-7-20
265	DC	10 pcs	7/20/18	7/20/18	0.00	0.00	DC		JUL 25 2018
270	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1		SA 18-7-20
280	QC21-FG	10 Ea	7/20/18	7/20/18	0.00	0.00	QC21		JUL 25 2018

Part Op 110 - 1-Beyel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 138795 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 11:05. OVEN TEMPERATURE: 550 FINISH TIME: 11:35.

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

Wing walk 5080995

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	5069554
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	5070426
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5085084
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	5092492
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	5077435
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	5079116
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging	
D2618	Bushing	20 Ea (2 ea)	250-Packaging	
D2856-400	Abrasion Strip 4" Wide (Per Foot)	12 Ea (1.2 ea)	250-Packaging	
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	79	0
	D3219-1	20	93	0
	D3272-1	10	10	0
180-Large Fab	D3065-041	10	1	0
	D3066-1	20	72	0
	MS20600-AD4W4	160	1,071	0
250-Packaging	AN3-35A	20	256	0
	AN4-13A	80	525	0
	AN5-36A	20	230	0
	D2230-3	40	191	0
	D2618	20	420	0
	D2856-400	12	48	0
	D3235-1	20	250	0
	D3278-041	10	19	0
	MS21042L3	20	2,638	0
	MS21042L4	80	2,392	0
	MS21042L5	20	696	0
	NAS1149D0363J	40	3,095	0
	NAS1149D0463J	160	3,234	0
	NAS1149D0563J	40	2,035	0

Part Specifications

Specifications could not be found.

Plex 3/22/18 3:38 PM Dart.Gagnon.Michelle

004344



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Container No: S090340



Part: D350-591-312

Job No: 174894

Serial No/Batch: S090340

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/10/18

3/22/2018

[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle



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D350-591-312
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Part No: D350-591-312

Job Qty: 10 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

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Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	10 Ea		7/18/18	0.00	0.00	Start Up Large Fab-4			JUL 12 2018 DNL 13-7-10
110	Large Fab	10 pcs		7/19/18	0.00	10.00	Large Fab 2			
120	QC	10 pcs		7/19/18	0.00	0.00	QC9			
130	QC	10 pcs		7/19/18	0.00	0.00	QC5			
140	HandFinish	10 pcs		7/19/18	0.00	1.87	HandFinish1			
150	QC	10 pcs		7/19/18	0.00	0.00	QC7-2			
180	Large Fab	10 pcs		7/19/18	0.00	10.00	Large Fab 2			
190	QC	10 pcs		7/19/18	0.00	0.00	QC10			
200	QC	10 pcs		7/19/18	0.00	0.00	QC5			
210	HandFinish	10 pcs		7/19/18	0.00	1.87	HandFinish1			
220	Powdercoat	10 pcs		7/19/18	0.00	2.98	Powdercoat1			
230	HandFinish	10 pcs		7/20/18	0.00	1.87	HandFinish3			
240	QC	10 pcs		7/20/18	0.00	0.00	QC3			
250	Packaging	10 pcs		7/20/18	0.00	0.00	Packaging1-3			JUL 12 2018
260	QC	10 pcs		7/20/18	0.00	0.00	QC4			
265	DC	10 pcs		7/20/18	0.00	0.00	DC			
270	Packaging	10 pcs		7/20/18	0.00	0.00	Packaging3-1			
280	QC21-FG	10 Ea		7/20/18	0.00	0.00	QC21			

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jlg DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	5064554
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	5070422
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5085084
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	5067891
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	5067892
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	5068056
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging	
D2618	Bushing	20 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" Wide (Per Foot)	20 Ea (2 ea)	250-Packaging 30072x2	5079659 x 11
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging	5069956
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging	5083384
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	5078707
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	5062378
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	5058178
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	5015209
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	5062379
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	5068062

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	79	0
	D3219-1	20	93	0
	D3272-1	10	10	0
180-Large Fab	D3065-041	10	1	0
	D3066-1	20	72	0
	MS20600-AD4W4	160	1,071	0
250-Packaging	AN3-35A	20	256	0
	AN4-13A	80	525	0
	AN5-36A	20	230	0
	D2230-3	40	191	0
	D2618	20	420	0
	D2856-400	20	48	0
	D3235-1	20	250	0
	D3278-041	10	19	0
	MS21042L3	20	2,638	0
	MS21042L4	80	2,392	0
	MS21042L5	20	696	0
	NAS1149D0363J	40	3,095	0
	NAS1149D0463J	160	3,234	0
	NAS1149D0563J	40	2,035	0

Part Specifications

Specifications could not be found.



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004344	S091165	AN3-35A	Bolt	S067891	ST348	20
004344	S091166	AN4-13A	Bolt	S067892	ST344	80
004344	S091146	AN5-36A	Bolt	S068656	ST336	20
004344	S091171	D2618	Bushing	S082275	ST008	20
004344	S079659	D2856-400-720	Abrasion Strip 4" X 7.20"	S079657	ST418	11
004344	S090792	D2856-400-720	Abrasion Strip 4" X 7.20"	s079659	ST418	2
004344	S092722	D2856-400-720	Abrasion Strip 4" X 7.20"	S092667	ST418	7
004344	S091218	D3235-1	Mounting Lug	S069956	ST522	20
004344	S091220	D3278-041	Support Assembly	S083384	ST522	10
004344	S091134	MS21042L3	Nut	s078167	Cycle Retire	20
004344	S091128	MS21042L4	Nut	s062378	ST303	80
004344	S091125	MS21042L5	Nut	s058178	ST303	20
004344	S091120	NAS1149D0363J	Washer	s015269	ST263	40
004344	S091119	NAS1149D0463J	Washer	s062379	ST263	160
004344	S091108	NAS1149D0563J	Washer	S068662	ST263	40

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

D2230.3

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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004344	S091165	AN3-35A	Bolt	S067891	ST348	20
004344	S091166	AN4-13A	Bolt	S067892	ST344	80
004344	S091146	AN5-36A	Bolt	S068656	ST336	20
004344	S088979	D2230-3	Mounting Lug	S088979	ST521	40
004344	S091171	D2618	Bushing	S082275	ST008	20
004344	S079659	D2856-400-720	Abrasion Strip 4" X 7.20"	S079657	ST418	11
004344	S090792	D2856-400-720	Abrasion Strip 4" X 7.20"	s079659	ST418	2
004344	S092722	D2856-400-720	Abrasion Strip 4" X 7.20"	S092667	ST418	7
004344	S091218	D3235-1	Mounting Lug	S069956	ST522	20
004344	S091220	D3278-041	Support Assembly	S083384	ST522	10
004344	S091134	MS21042L3	Nut	s078167	Cycle Retire	20
004344	S091128	MS21042L4	Nut	s062378	ST303	80
004344	S091125	MS21042L5	Nut	s058178	ST303	20
004344	S091120	NAS1149D0363J	Washer	s015269	ST263	40
004344	S091119	NAS1149D0463J	Washer	s062379	ST263	160
004344	S091108	NAS1149D0563J	Washer	S068662	ST263	40

S088979

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Hel-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Hel-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Hel-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Hel-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Hel-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Hel-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY